

Work Order ID 83418

April-18-12 8:10:26 AM

83418

Page 1

Item ID: D2939-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle RH In, 206

Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/04/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

FK 12/07/08

10

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

FK 12/07/08

10

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

QC1- Inspect dimensions to dimension sheet

0.00

120

QC

Memo

0.00

FK 12/07/08

10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83418

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Page 2

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Start Date: 18/04/2012 Start Qty: 6.00

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Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

3200

M121841

10 10

10 24 12-7-10

10 X 10 MF 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 83418***83418***

Page 3

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Revision ID:

Stop ***NS2***

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Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Insp Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>428A</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

10x 4 11/02/10

102 12-7-11 Sy

CK 12/7/12

11/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-18-12 8:10:30 AM

Page 1

Work Order ID: 83418

83418

Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	57.0000	1	6			
D6101-001									**	10		SI 12/07/06	
Saddle Billet													

Location	Loc Qty	Loc Code
MAT040	3	
69677	2	
76836	1	
MAT041	54	
80764	4	
→ 81923	50	
		10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83418
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**

 ☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140						
B	0.100	0.140						
C	0.100	0.140						
D	0.210	0.230						
E	1.245	1.255						
F	1.245	1.255						
G	2.495	2.505						
H	0.510	0.515						
I	1.572	1.582						
J	2.495	2.505						
K	0.257	0.262						
L	0.312	0.317						
M	0.235	0.240						
N	0.100	0.140						
O	0.540	0.560						
P	0.490	0.510						
Q	3.715	3.725						
R	2.720	2.760						
S	0.240	0.270						
T	0.100	0.180						
U	1.625	1.635						
V	1.362	1.372						
W	0.316	0.321						
X	1.250	1.270						
Y	1.565	1.585						
Z	0.178	0.198						
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

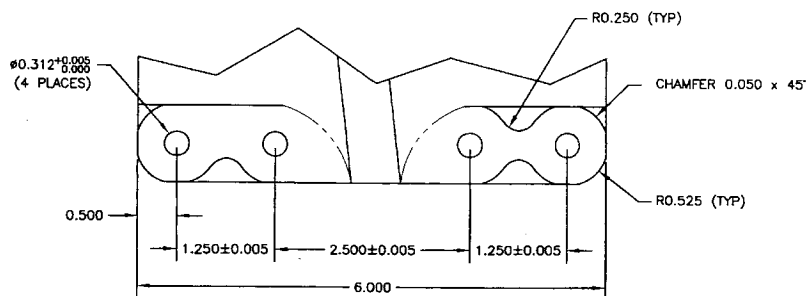
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

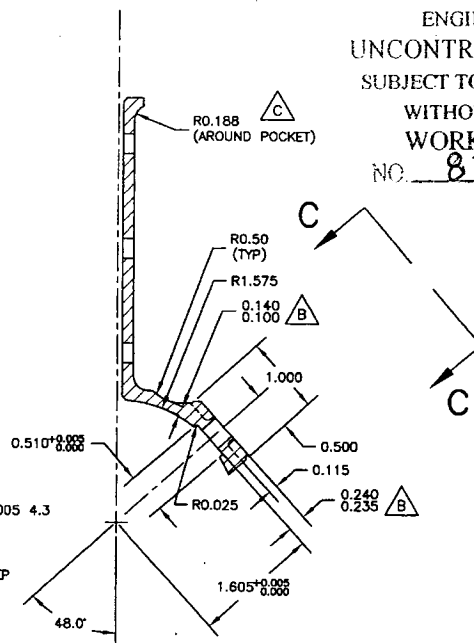
NOTE: Date & initial all entries



VIEW C-C

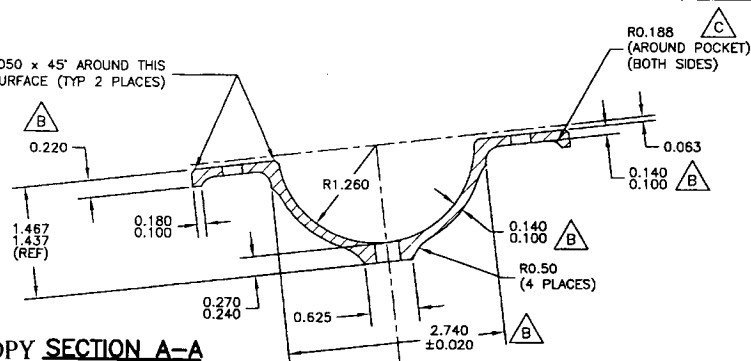
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)

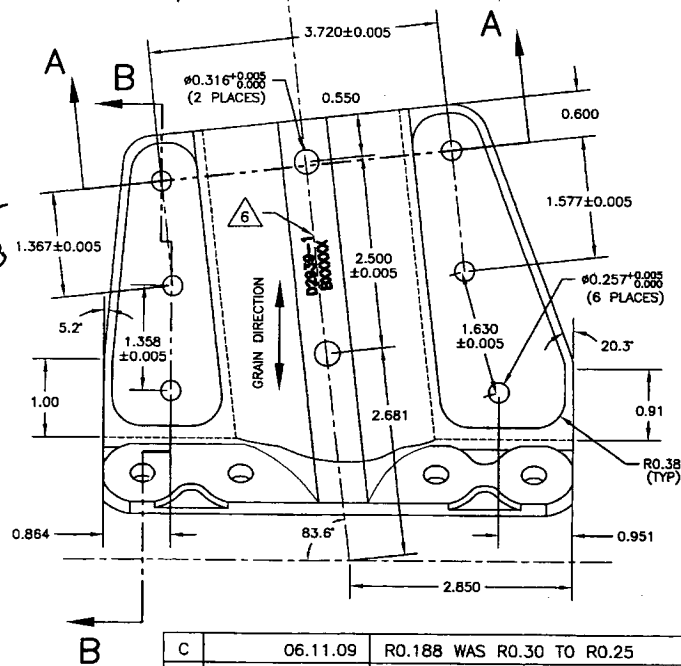


SHOP COPY SECTION A-A

RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 83418

MLJ
 12/04/18



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

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DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	TITLE	D2939	SHEET 1 OF 1
06.11.09	SADDLE INSIDE		SCALE 2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50476
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.103	.108	.108	.108	.108
B	0.100	0.140		.103	.108	.108	.108	.107
C	0.100	0.140		.119	.119	.116	.116	.116
D	0.210	0.230		.224	.224	.224	.224	.223
E	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.120	.121	.119	.120	.120
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.497
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.252	.250	.250	.251
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.317	.317	.317	.317	.317
X	1.250	1.270		1.2615	1.261	1.260	1.2615	1.261
Y	1.565	1.585		1.574	1.576	1.574	1.575	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: F.K.	Date: 12/07/08
Audited by: <i>amf</i>	Date: 12/07/09
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 22172	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	0.100	0.140		.108	.108	.108	.108	.108
B	0.100	0.140		.108	.108	.108	.108	.108
C	0.100	0.140		.119	.120	.120	.120	.120
D	0.210	0.230		.223	.223	.223	.223	.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.120	.120	.120	.120	.120
O	0.540	0.560		.551	.550	.550	.550	.550
P	0.498	0.510		.497	.498	.498	.497	.497
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.250	.250	.250	.251
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.317	.317	.317	.317	.317
X	1.250	1.270		1.261	1.260	1.261	1.260	1.261
Y	1.565	1.585		1.576	1.576	1.576	1.575	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: <i>FB</i>	Date: 12/07/08
Audited by: <i>AK</i>	Date: 12/07/09
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
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